

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-01 **Date Opened:** 03 Jan 17 **Title:** Fabrication**Aircraft OEM:** Bell **Aircraft Model:** 206L/407 **Product Type:** Mounting Beams **Product Model:** High **Quantity:** 1 aft**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

DB
N/A
DB
DB
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76630	0	Beams	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1 aft
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: Andrew BartfaiSign: SCA: AD07Date: 03-Jan-17

ICC / Dual Inspection preformed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 11-Jan-17

Work Order closed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 11-Jan-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0019
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-01
6. Item 1.	7. Description Aft Beam Ass'y	8. Part Number 76630-02	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 11 Jan 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

ALPINE HELICOPTERS

MOUNTING BEAM FABRICATION – 76630

General

These instructions apply to mounting beams 76630-01 (forward) and 76630-02 (aft) for Bell 206L/407 high mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

76630, Revision 0 – Beams

Work Order: 2017-01

Batch Quantity: 1 AFT

Date Open: 03 JAN 2017

Complete
(initial or SCA #)

AD
73-04
01

1. Beam Fabrication – 1x2 tubes

- a. Cut 1 x 2 x 0.12 material as indicated on drawings.
 - i. 76630-01: 76630-03 (long tube)
 - ii. 76630-02: 49222-04 (inboard tube), 49222-05 (corner tube), 76630-06 (outboard tube)
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder.
- d. Remove writing on tubes with acetone.
- e. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining

- a. Run CNC programs to machine keyways, slots and holes in component parts.
- b. De-burr keyways, slots and holes.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD02

3. Beam Fabrication – Components

Note: Check stock before making components.

- a. Shear and bend caps: 76630-10, 69830-19, 69830-20, 69831-20.
- b. Cut and turn 49222-07 and 49222-08 bushings and 76630-13 guide tubes:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. 49222-07 only: Drill F through at 300 RPM
 - iv. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - v. Setup stop and face other end to length @ 1000 RPM.
 - vi. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- c. Cut and turn 76630-14 Stops:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. Drill #9 through at 300 RPM. Countersink 90° to fit #10 screw.
 - iv. De-burr outside with a file at 300 RPM.
 - v. Setup stop and face other end to length @ 1000 RPM.
 - vi. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- d. Cut 76630-15 pin.
- e. Cut 69830-07 blocks.
- f. Record component POs / WOs on attached material list.

AD
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01

MOUNTING BEAM FABRICATION – 76630

Complete
(initial or SCA #)

AD
73-04
05

4. Beam Welding – 76630-01

- a. TIG weld 76630-13 guide tubes into 76630-03 tubes using ER308L rod, two places per tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 49222-07 bushings into 76630-03 tubes using ER308L rod, two places per tube, both sides.
- c. TIG weld 76630-15 pins into 76630-03 tubes using ER308L rod, two places per tube, both sides.
- d. TIG weld 49222-08 bushings into 76630-03 tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- e. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing.
 - ii. 69830-07 stops over outboard keyways.
 - iii. 69830-20, 76630-10 caps.
- f. Record component and welding rod POs / WOs on attached material list.
- g. Tag in-progress parts for finishing.

AD
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05

5. Beam Welding – 76630-02

- a. TIG weld 76630-13 guide tubes into 76630-06 tubes using ER308L rod, two places per tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 49222-07 bushings into 76630-06 tubes using ER308L rod, two places per tube, both sides.
- c. TIG weld 76630-15 pins into 76630-06 tubes using ER308L rod, two places per tube, both sides.
- d. TIG weld 49222-08 bushings into 76630-04 tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- e. TIG weld 76630-04, 76630-05, 76630-06 tubes using ER308L rod. Clamp tubes to a rigid fixture to maintain the tubes parallel and straight.
- f. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing.
 - ii. 69830-07 stops over outboard keyways.
 - iii. 69830-20, 76630-10 caps.
- g. Record component and welding rod POs / WOs on attached material list.
- h. Tag in-progress parts for finishing.

AD
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07

6. Beam Finishing

Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - ii. Use a block to distribute press loads, about 2" wide
 - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts for inspection.

MOUNTING BEAM FABRICATION – 76630

Complete
(initial or SCA #)

7. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 76630-01 and 76630-02 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

AD
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02

AD
73-04
01

8. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

PAINTED
AD02

9. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into outboard guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Install #10-32 x 2.5" countersunk screw and 76630-14 stop into inboard guide with NAS1149C0363R washer and MS21044C3 nut.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Green tag completed beam assemblies and place into stock.

AD
73-04
02

WO#Rev. Original 27 May 2013

Work Order: 2017-01Material Tracking Sheet
Bell 206L / 407 HIGH Aft Mounting Beams

1 of 2

Date Open: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		69831-02 <u>76630-02 JK</u>	Aft Beam Assembly		
Step 1				<i>Fabrication</i>		
	. 1		49222-04	Tube	304 Stainless, 1x2x0.125 tube	<u>15073</u>
	. 1		49222-05	Tube	304 Stainless, 1x2x0.125 tube	<u>15073</u>
	. 1		76630-06	Tube	304 Stainless, 1x2x0.125 tube	<u>15073</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 2		49222-07	Bushing	316 Stainless, 5/8" rod	<u>16002</u>
	. 2		49222-08	Bushing	316 Stainless, 5/8" x 0.120 tube	<u>15024</u>
	. 1		69830-16	Strap	304 Stainless, 0.105" Sheet	<u>13083</u>
	. 2		69830-17	Block	304 Stainless, 3/16" x 3/4" bar	<u>2016-77</u>
	. 1		76630-10	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 1		69831-20	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 2		76630-13	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	<u>15073</u>
	. 2		76630-15	Pin	304 Stainless, 5/16" Rod	<u>15073</u>
Step 5				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>14028</u>
Step 6				<i>Straightening</i>	<i>None</i>	
Step 7				<i>Inspection</i>	<i>None</i>	
Step 8				<i>Powder Coating</i>		<u>N/A - PAINTED</u>

Work Order: _____

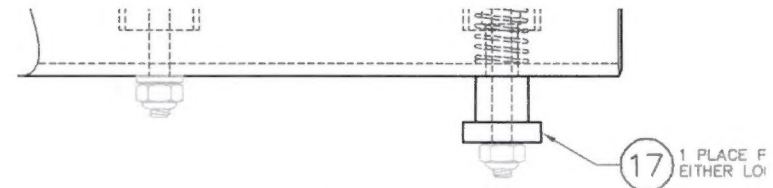
Material Tracking Sheet
Bell 206L / 407 HIGH Aft Mounting Beams

2 of 2

Date Open: _____

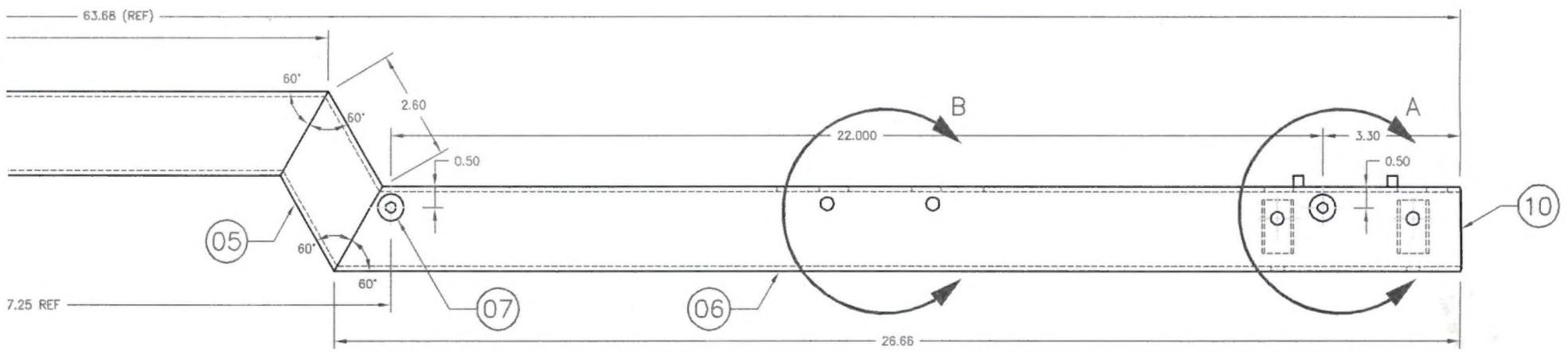
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 9				<i>Final Assembly</i>		
Step 9.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 9.c.	. 1		76630-14	Stop	6061-T6 Aluminum, 0.75" Rod	10086
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	16016
	. 1		NAS1149C0363R	Washer		15086
	. 1		MS21044C3	Nut		13048
Step 9.d.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	

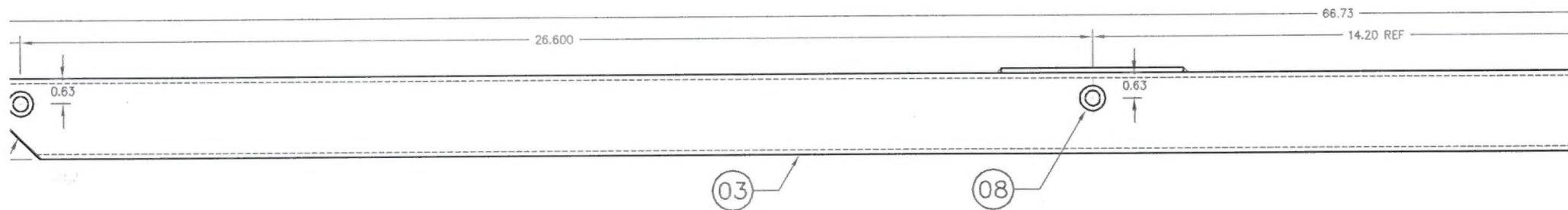
APPROVALS		DATE	AL CONSULTING ENGINEER 2013 - 39TH tel: (403) 250-8000
DRAWN:	JEFF CLARKE	10 SEPT 2007	
CHECKED:	E. BURGAIN		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			C
DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			
			SCALE 1 : 2
			SHEET 1 OF 1



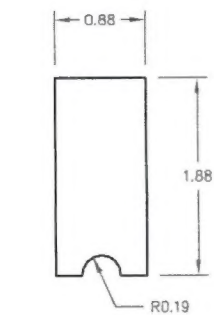
DETAIL A
SCALE 1 : 1
FINAL ASSEMBLY AFTER POWDER COATING

1 08)

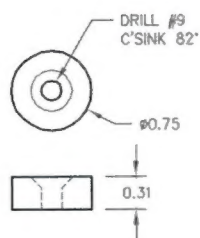




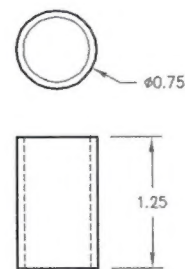
(01) FORWARD BEAM ASSEMBLY



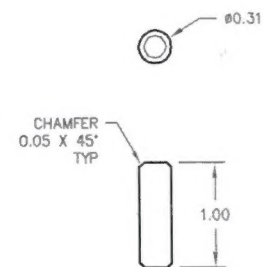
(10) CAP
SCALE 1 : 1



(14) STOP
SCALE 1 : 1

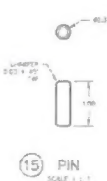
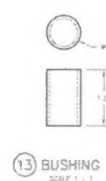
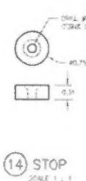
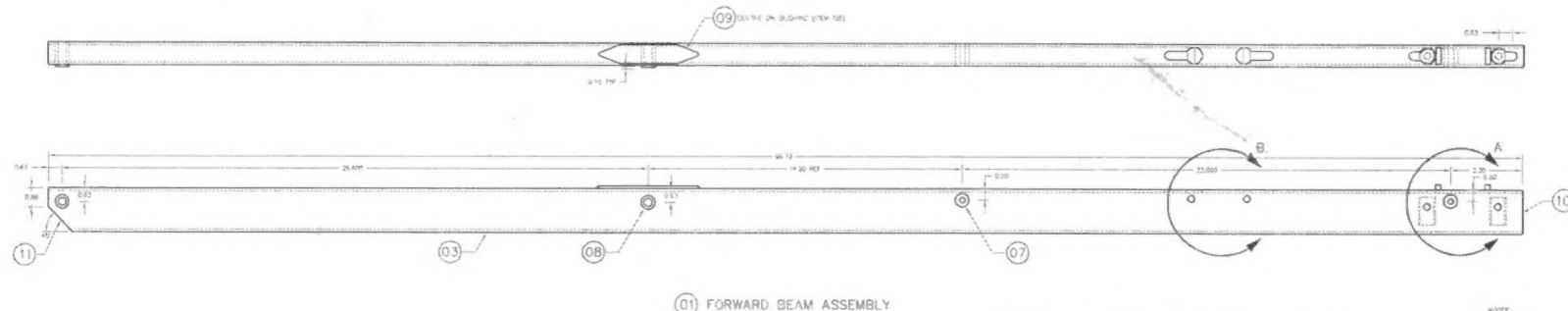
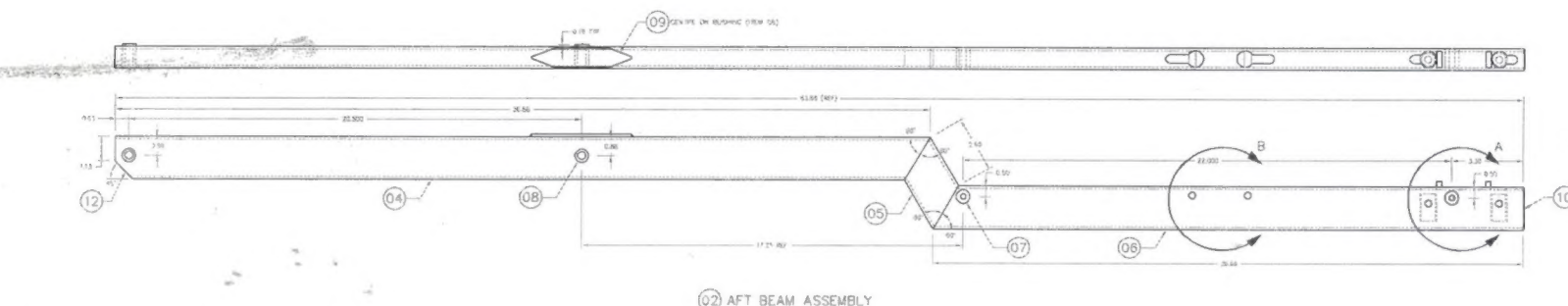
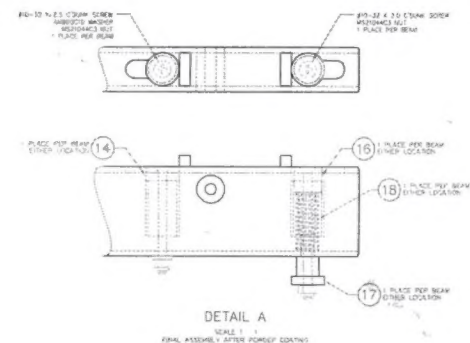
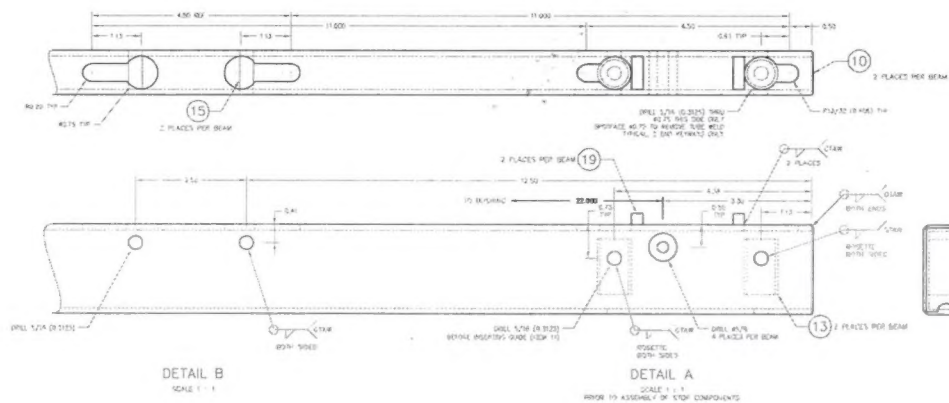


(13) BUSHING
SCALE 1 : 1



(15) PIN
SCALE 1 : 1

THE DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. "AS DRAWN" OR ANY PREVIOUS EDITION. ANY USE OF THIS DRAWING FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY INTENDED IS PROHIBITED. ANY REPRODUCTION OF THIS DRAWING FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY INTENDED IS PROHIBITED. ANY REPRODUCTION OF THIS DRAWING FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY INTENDED IS PROHIBITED.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		



QTY	REV	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	00000-01 01 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-02 02 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-03 03 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-04 04 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-05 05 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-06 06 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-07 07 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-08 08 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-09 09 BUSHING	STAINLESS STEEL	COMMERCIAL	
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1	1	00000-96 96 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-97 97 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-98 98 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-99 99 BUSHING	STAINLESS STEEL	COMMERCIAL	
1	1	00000-100 100 BUSHING	STAINLESS STEEL	COMMERCIAL	

NOTES			
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.			
2. MILLING OF STAINLESS STEEL TO BE COMPLETED BY CNC METHOD TO AVERAGE MILLING AND SHALL CONFORM TO D2000, OR EQUIVALENT FOR STAINLESS STEEL.			
3. ALL STEEL PARTS TO BE THOROUGHLY DEBURRED AND POWDER COATED PRIOR TO INSTALLATION.			
APPROVALS			
DATE		DATE	
JAY CLARKE		30 SEPT 2007	
E. BURROGH			
AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, BARBIE			
3013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2B 3B7			
TEL: (403) 243-8887 FAX: (403) 243-8888 WWW.AERODESIGNLTD.COM			
BELL 206L & 407			
CARGO BASKET INSTALLATION			
BEAMS			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		SCALE 1 : 2	
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